

# Work Order ID 116223

April-08-14 1:44:19 PM

Item ID: D4034-041

Revision ID:

Item Name: Aft Upper Rib Assembly

Start Date: 4/08/14 Start Qty: 5.00

Required Date: 4/14/14 Req'd Qty: 5.00

Reference:

Approvals: Process Plan: *MCS*  
QC:

Date: *14-04-08*

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tooling:

SPC (Y/N):

Date:

Date:

Run Start \*NR1\*

Stop \*NR2\*

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

Draw Nbr

Revision Nbr

D4034

C

100

Weld per dwg A/R S.S. rod Batch: *B123823*

0.00

\*100\*

Large Fab

Memo

0.00

Large Fab

1- Assemble ribs to hoop and weld as per dwg DT9564

2- Weld bushing in rib and grind weld flush as per dwg

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

\*110\*

QC

Memo

0.00

Quality Control

120

QC5- Inspect part completeness to step on W/O

0.00

\*120\*

QC

Memo

0.00

Quality Control

\*116223\*

Page 1

Accept

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

*5x CC 14-4-8*

*5x* **DAS 43 9-89** *14-4-9*

*5x* **DAS 43 9-89** *14-4-9*

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Revision ID:

Item Name: Aft Upper Rib Assembly

Start Date: 4/08/14 Start Qty: 5.00

Required Date: 4/14/14 Req'd Qty: 5.00

Reference:

Approvals: Process Plan: Date:

QC: Date:

Sequence ID/  
Work Center ID

130

**\*130\***

Packaging

Packaging

140

**\*140\***

QC

Quality Control

Operation  
Description

Identify as per dwg & Stock Location: W/A

Memo

QC21- Final Inspection - Work Order Release

Memo

**\*116223\***

Page 2

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Stop **\*NS2\***

Cust Item ID:

Customer:

Run Start **\*NR1\***

Stop **\*NR2\***

Tooling:

Date:

SPC (Y/N):

Date:

Set Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

0.00

0.00

0.00

0.00

5x CC 14-4-9

14/4/9

① 14-04-09

# Picklist Print

April-08-14 1:44:25 PM

Page 1

Work Order ID: 116223

\*116223\*

Parent Item: D4034-041

\*D4034-041\*

Parent Item Name: Aft Upper Rib Assembly

Start Date: 4/08/14

Required Date: 4/14/14

Start Qty: 5.00

Required Qty: 5.00

## Comments:

IPP RevA: new issue DD 09.11.23 verified by:EC  
per dwg revA 10.03.15 verified by:EC  
DWG REV.B DD VERF:EC  
REV.pcl DD VERF:JLM  
IPP Rev:B as  
IPP Rev:C 11.01.19 AS PER  
IPP Rev:D 13.03.14 AS PER DWG  
IPP REV:E 13.06.21  
DWG REV.C DD  
VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4034-1		Manufactured	No			100	Each	12.0000	1	5			
									**	CC 14-4-8			
*D4034-1*													
Rib													

Location	Loc Qty	Loc Code
WA004	12	
110319	1	
115523	11	

D4034-3  
Rib

Manufactured No

100 Each 20.0000 1

\*\*

CC 14-4-8

Location	Loc Qty	Loc Code
WA004	20	
103361	2	
108090	18	

D4021-7  
Hoop

Manufactured No

100 Each 12.0000 1

\*\*

CC 14-4-8

Location	Loc Qty	Loc Code
WA004	12	
107651	1	
113157	11	

# Picklist Print

April-08-14 1:44:25 PM

Work Order ID: 116223

Parent Item: D4034-041

Parent Item Name: Aft Upper Rib Assembly

D4021-9

Manufactured No

**\*D4021-9\***

Bushing

**\*116223\***

**\*D4034-041\***

Start Date: 4/08/14

Required Date: 4/14/14

Start Qty: 5.00

Required Qty: 5.00

100

Each

90.0000

4

20

\*\*

CC 14-4-8

Location

Loc Qty

Loc Code

WA004

90

107634

90

20x

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

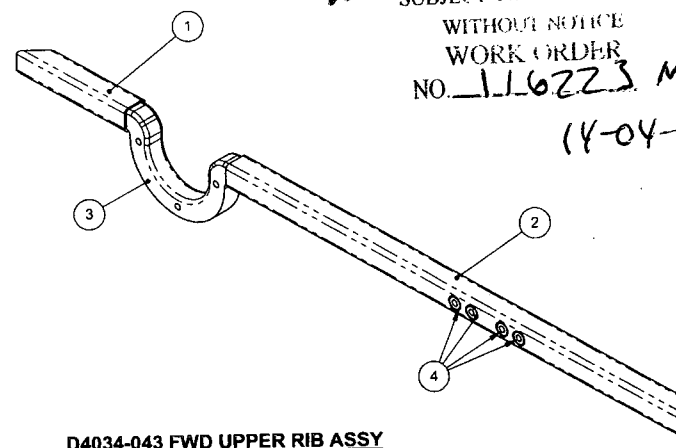
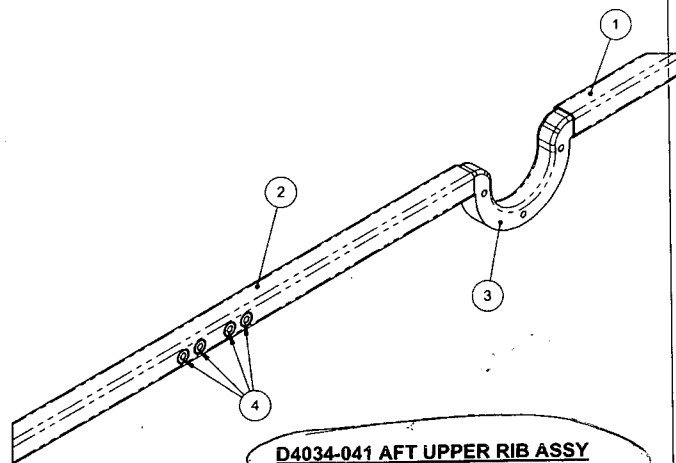
Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%; border: none;"> <tr> <td style="width:25%;">Skid-tube <input type="checkbox"/></td> <td style="width:25%;">Crosstube <input type="checkbox"/></td> <td style="width:25%;">Water Jet <input type="checkbox"/></td> <td style="width:25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY			
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other  _____ _____ _____

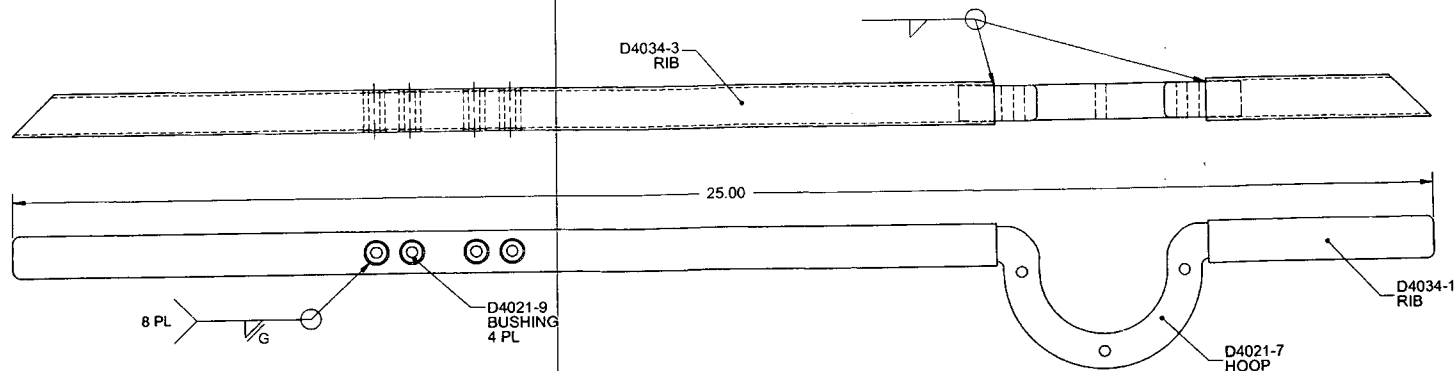
ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4034-041	AFT UPPER RIB ASSY
		X	D4034-043	FWD UPPER RIB ASSY
1	1	1	D4034-1	RIB
2	1	1	D4034-3	RIB
3	1	1	D4021-7	HOOP
4	4	4	D4021-9	BUSHING



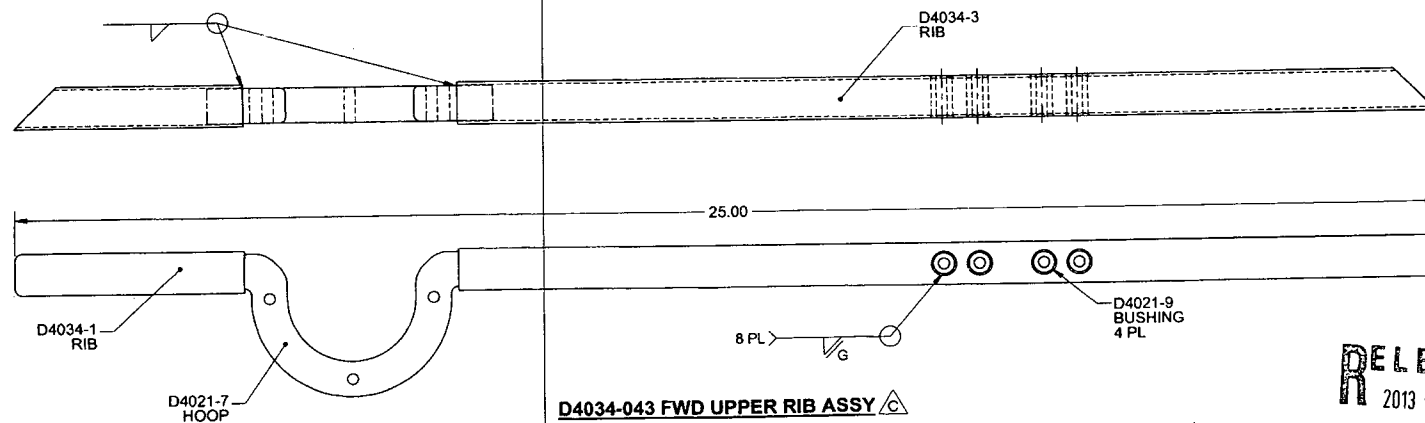
SHOW COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 116223 MLC  
 14-04-08

RELEASED  
 2013-06-20  
 M

C	-043 REDESIGNED AS MIRROR IMAGE OF -041. -5 DELETED. D2327-3 DELETED. REASON PROP ARM NO LONGER OFFERED.	AJS	13.03.13
B	ADDITIONAL HOLES ADDED ON D4034-3 RIB	SC	10.12.20
A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.	AS	D4034	SHEET 1 OF 3
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	UPPER RIB ASSY, BASKET BASE	NTS
DATE	13.03.13	COPYRIGHT © 2013 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



**D4034-041 AFT UPPER RIB ASSY**



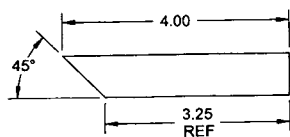
**D4034-043 FWD UPPER RIB ASSY**

**RELEASED**  
2013-06-20

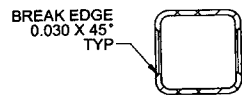
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.61 lbs
- 8) WELD PER DART QSI 004

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D4034	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	UPPER RIB ASSY, BASKET BASE	NTS
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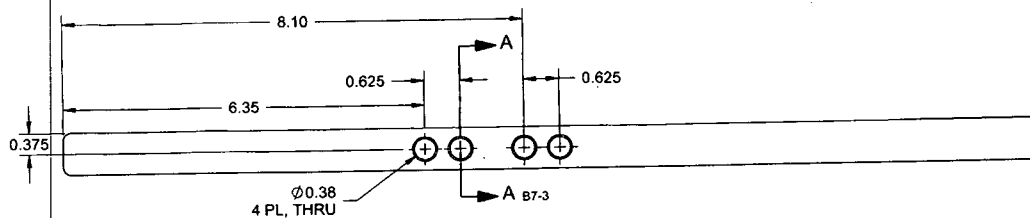
**D4034-1 RIB**



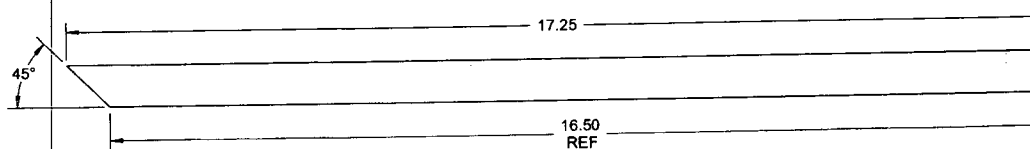
**SECTION A-A C3-3**

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.13 lbs  
-3: 0.62 lbs



**D4034-3 RIB**



**RELEASED**  
2013-06-28

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. C
MFG. APPR.	AJS	D4034	SHEET 3 OF 3
APPROVED	AJS	TITLE	SCALE
DE APPR.	AJS	UPPER RIB ASSY, BASKET BASE	NTS
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